

Date: Thursday, 31/07/2008 2:01:46 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	REAR RAIL
Job Number :	40865		
Estimate Number :	13494		
P.O. Number :		Part Number :	D37663
This Issue :	31/07/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3766 REV B
First Issue :	31/07/2008	Project Number :	N/A
Previous Run :	40710	Drawing Revision :	B
		Material :	
		Due Date :	08/08/2008
Written By :		Qty:	16 Um: Each
Checked & Approved By :	<i>JD 08-8-01</i>		
Comment :	Est Rev:A 08-07-21 revB as per dwg DD verified by:EC		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6T1000W188

6061T6 RD TUBE 1.00 X .188W



Comment: Qty.: 2.9323 f(s)/Unit Total: 46.9174 f(s)

6061T6 RD TUBE 1.00 X .188W

batch: *M104779**mmf 08/08/13**FF 08-08-12**(16)*

2.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-cut tube to length as per dwg D3766

2-drill holes thru to finish size as per dwg D3766

3- deburr

*21/11/08/08/12 mmf 08/08/13**FF 08-08-12**(16)*

3.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*08/08/13**(16)*

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per-QSI 005 4.1

*08-08-19**(16)*

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*08-08-19**(16)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 31/07/2008 2:01:46 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: REAR RAIL

Job Number: 40865

Part Number: D37663

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 513

8/8/20

2/16

7.0

QC21

FINAL INSPECTION/W/O RELEASE



08/08/2008

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-0820

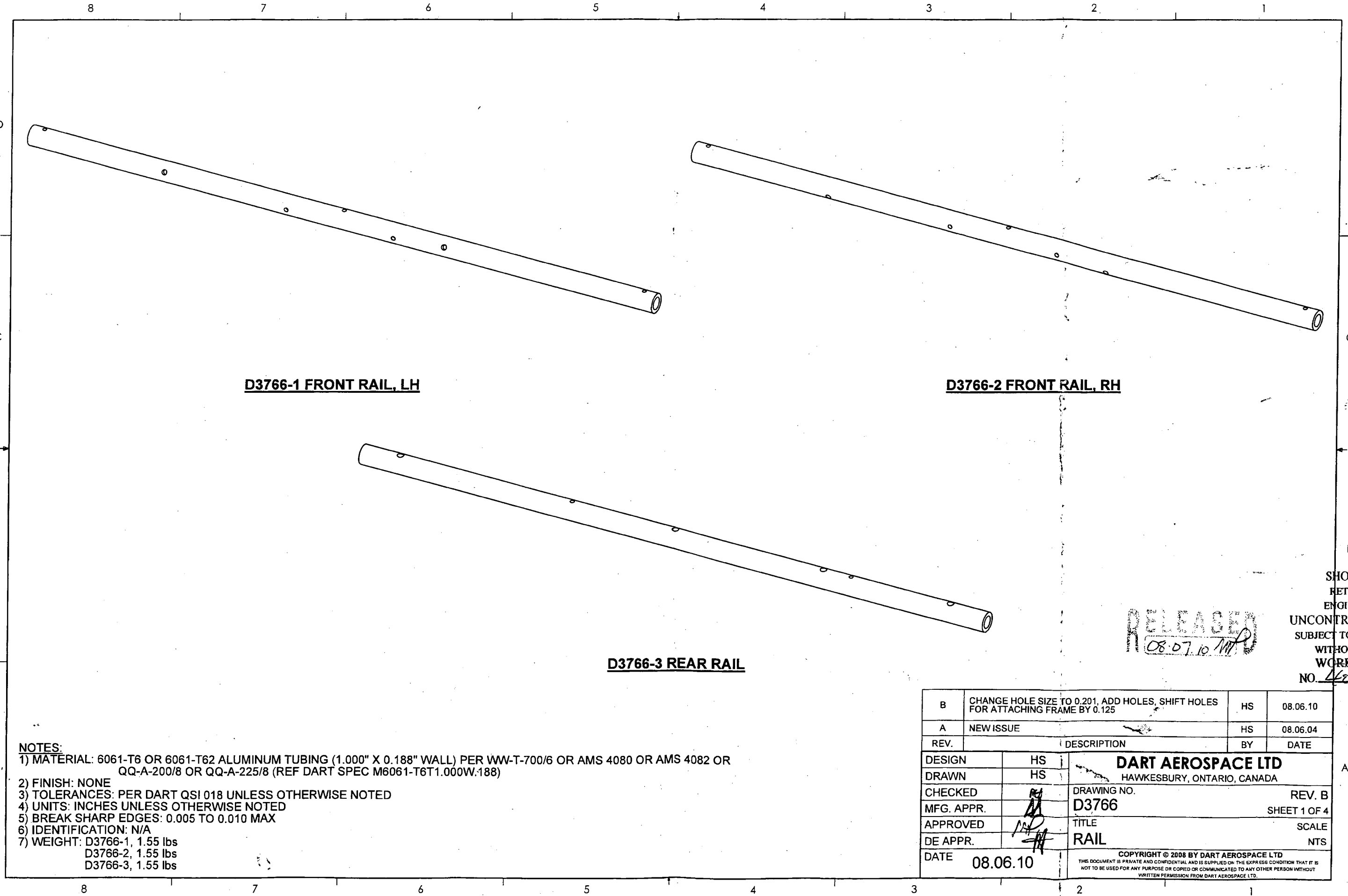
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3766-1 FRONT RAIL, LH

D3766-2 FRONT RAIL, RH

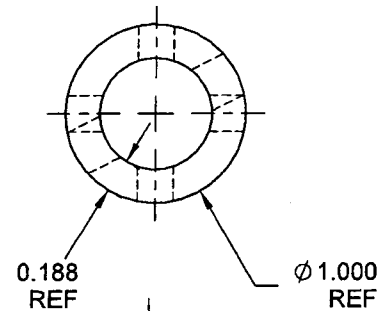
D3766-3 REAR RAIL

RELEASED
08.07.10

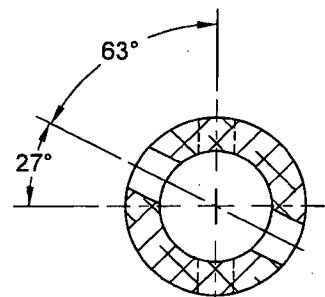
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WORK ORDER
NO. 40805

NOTES:
1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.000" X 0.188" WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF DART SPEC M6061-T6T1.000W.188)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: D3766-1, 1.55 lbs
D3766-2, 1.55 lbs
D3766-3, 1.55 lbs

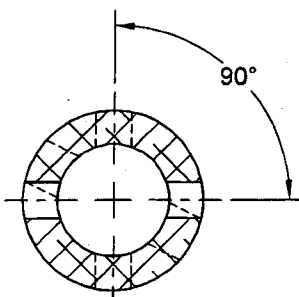
B	CHANGE HOLE SIZE TO 0.201, ADD HOLES, SHIFT HOLES FOR ATTACHING FRAME BY 0.125	HS	08.06.10
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3766	SHEET 1 OF 4
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DE APPR.		RAIL	NTS
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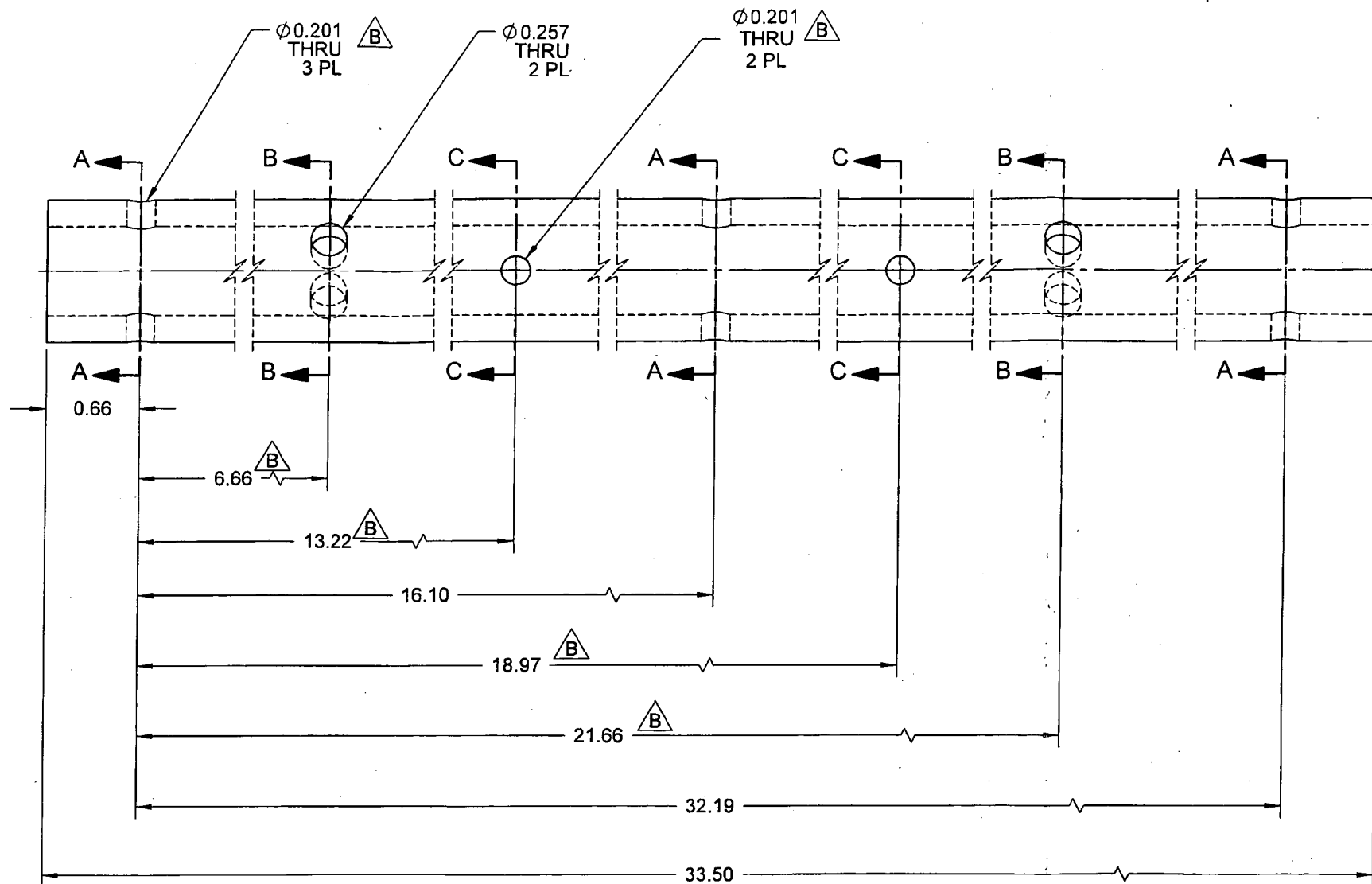
SECTION A-A



SECTION B-B







SECTION C-C

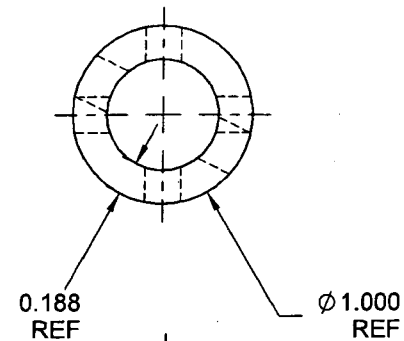


D3766-1 FRONT RAIL, LH

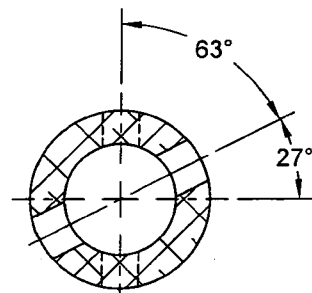
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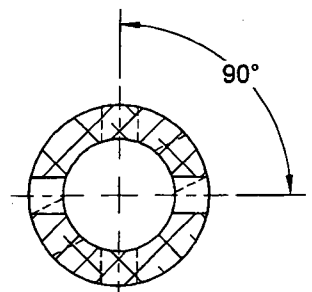
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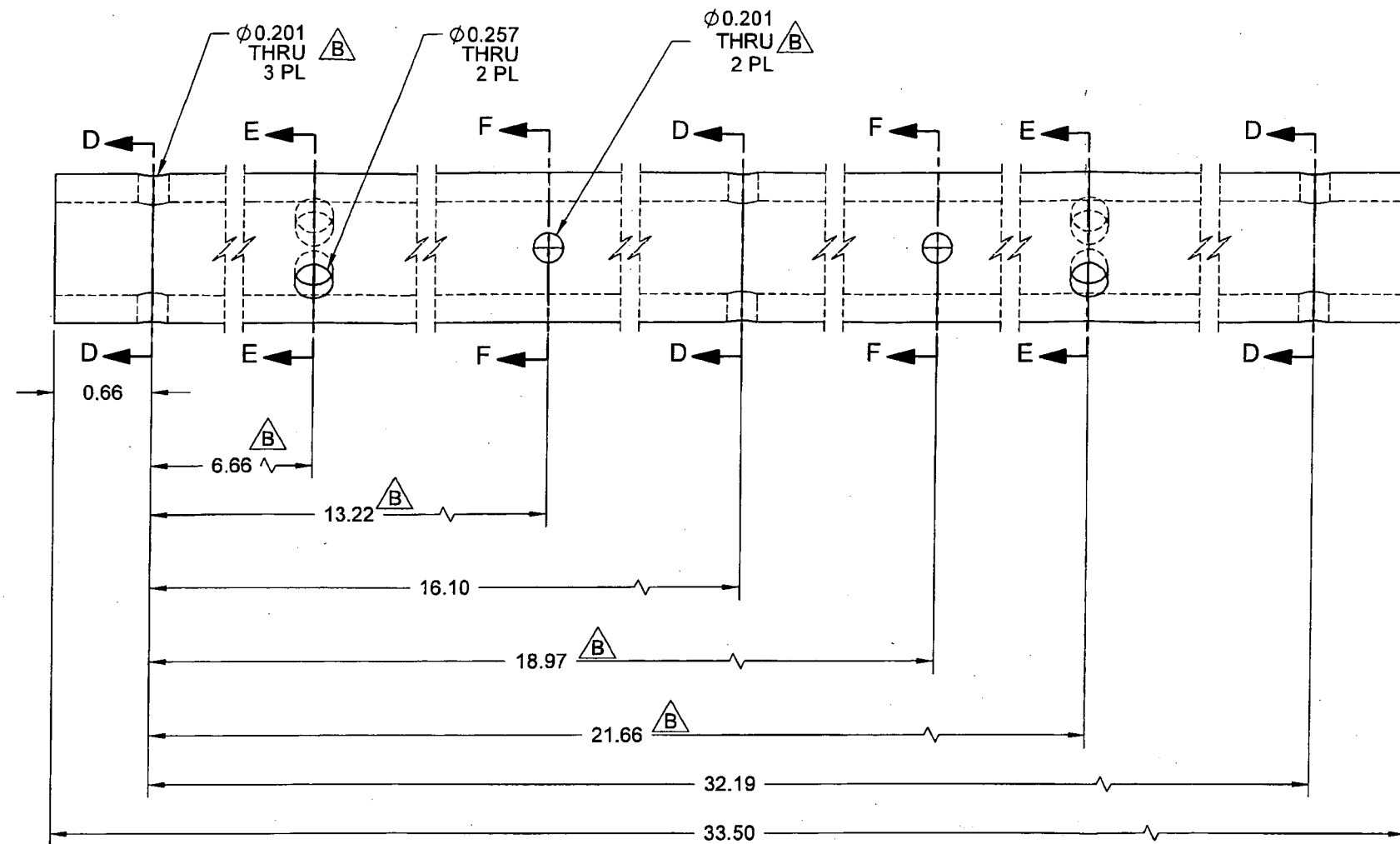
SECTION D-D



SECTION E-E







SECTION F-F



D3766-2 FRONT RAIL, RH

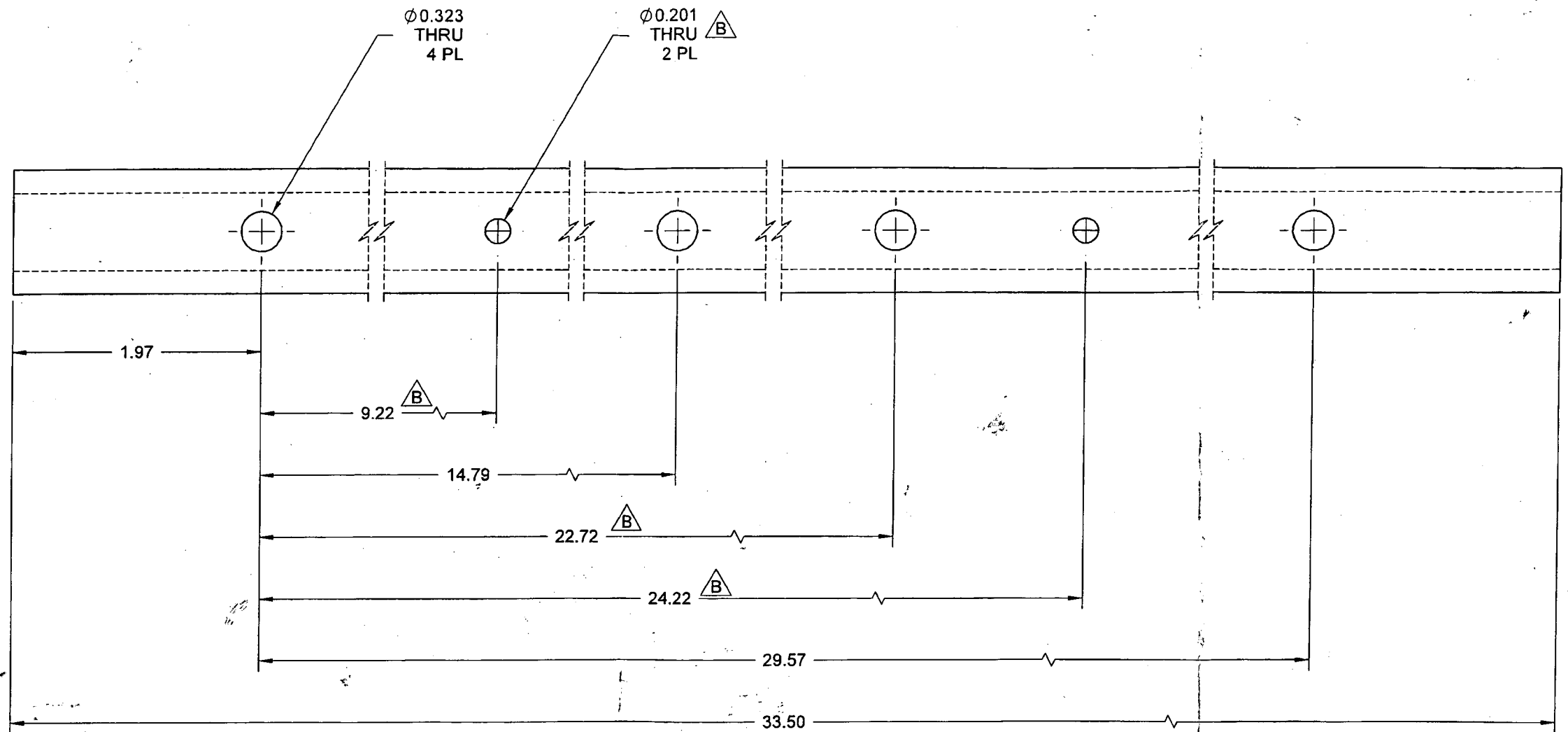
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0.188
REF

Ø1.000
REF



D3766-3 REAR RAIL

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